

54656 DREV

Work Order ID 54169

December 2, 2009 8:01:13 AM



Page 1

Item ID: D135-751-011

Revision ID: C

Item Name: Skidtube Installation

Start Date: 02/12/2009 Start Qty: 1.00

Required Date: 10/12/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: BP Date: 02/12-2

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3507

Rev C

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D135-751-011

0.00

0.00

CHG001

8 or 12/14

110



Skidtubes

Skidtubes

Skidtubes

Memo

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Open holes to 0.3125".

3- Deburr holes.

0.00

0.00

> DP 9-12-2

54169

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54169

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Page 2

Item ID: D135-751-011

Revision ID: C

Item Name: Skidtube Installation

Start Date: 02/12/2009 Start Qty: 1.00

Required Date: 16/12/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



CNC Bend I

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

- 1- Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".
- 2- Cut FWD END of tube as per dwg D3507

0.00

0.00

9-12-2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D135-751-011
Revision ID: C
Item Name: Skidtube Installation

Start Date: 02/12/2009 Start Qty: 1.00
Required Date: 16/12/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling: _____ Date: _____
SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Aft end as per dwg D3507								
	2-Deburr ends								
	3-Drill Aft & Fwd Cap holes using DT8678 & DT8901								
	4-Locate DT8870 & Drill Ground wire hole on top of Tube.								
	6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****								
	7-Open crossbolt holes to 0.125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.								
	8-Open six rear wearplate holes using DT8892. Open holes to 0.297"								
	9-Drill holes section G-G (DT9434)- N/A								
	10-Open Aft & Fwd Cap holes using .208" drill.								
	11-Bore out aft end of tube as per Dwg D3507 & Detail "B".								
	12-Open ground wire hole .297" section E-E								
	13- Section G-G holes must be laid out manually, open to #30.								
	14-Deburr holes.								

9-12-3

9-12-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D135-751-011
Revision ID: C
Item Name: Skidtube Installation

Start Date: 02/12/2009 Start Qty: 1.00

Required Date: 16/12/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

278 69/12/07

①

f

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

1

11/9/12/7

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

DP

9-12-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 02/12/2009 Start Qty: 1.00

Required Date: 16/12/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

Skidtubes

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M112295

Exp Date: 10/12/10

5-Weld x-bolt (D3504-1/3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD

Batch: M112860

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

0.00

0.00

M 9/12/17

09/12/08

09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

180

QC10- Inspect visual per QSI004- ground welds



QC

Memo

Quality Control

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

278 09/12/08

0.00

190

Skidtubes



Skidtubes

Memo

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

0.00

0.00

BE 09/12/08

200

QC5- Inspect part completeness to step on W/O



QC

Memo

Quality Control

0.00

278 09/12/09

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 54169

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Revision ID: C

Item Name: Skidtube Installation

Start Date: 02/12/2009 Start Qty: 1.00

Required Date: 16/12/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

BF 02-12-9

①

Hand Finishing

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 112148

Memo

0.00

BF 02-12-10

①

Powder Coating

START TIME: 8:20

OVEN TEMPERATURE: 320°

FINISH TIME: 8:50

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

M 09/12/10

①

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 54169

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Start Date: 02/12/2009 Start Qty: 1.00

Required Date: 16/12/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240



HandFinish

HandFinishing

Memo

0.00

0.00

= 7/11 09/12/10

(X1)

Ø

Hand Finishing

Install Wearplate & Ground Wire inserts as per Dwg D3507.

250



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Inspect Inserts

0.00

0.00

5 09/12/10

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 54169

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Item ID: D135-751-011
Revision ID: C
Item Name: Skidtube Installation

Start Date: 02/12/2009 Start Qty: 1.00
Required Date: 16/12/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Run Start



Stop



Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260



HandFinish

Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

✓ A/R 241 Sika Flex Batch: M112345
Exp Date: 10/08

3-Install Wearplates as per Dwg D3507

✓ Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Screws where indicated on Dwg (Note #6)

✓ A/R 241 Sika Flex Batch: M112345
Exp Date: 10/08

✓ 4-Install Plug assembly as per Dwg D3507

✓ And Apply Lubricate Batch: M101222

✓ Wing Walk as per Dwg D3507 and QSI 005 4.4

M112263

=> M 09/12/10

(X1)

✓

270



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 8 02/12/11

(40)

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54169

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Item ID: D135-751-011
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Start Date: 02/12/2009 Start Qty: 1.00
Required Date: 16/12/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/12/11 R S

290

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

⇒ 8 on 12/14

⊗

300

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D135-751-011
Location: _____
PPP Rev: B

12/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 54169

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Item ID: D135-751-011
Revision ID: C
Item Name: Skidtube Installation

Accept



Setup Start



Stop



Start Date: 02/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.12.16

09.12.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 1

December 2, 2009 8:01:19 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation


Comments:

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2962-150RevA		Manufactured	No			110	Each	40.0000	1.0000			
												
3.540 Outer Tube, Extrud												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40

27774

1

28672

39

170

Each

11.0000

2.0000

D3504-1RevC

Manufactured

No



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

31234

11

170

Each

14.0000

1.0000

D3504-3RevC

Manufactured

No



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

31232

14

DP 9-12-2
⑦

2 BE 09/12/08

1 BE 09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

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Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3504-5RevC

Manufactured No

170

Each

6.0000

2.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

36181

6

170

Each

2.0000

1.0000

D3505-1RevA

Manufactured No



Web

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

52171

2

190

Each

89.0000

4.0000

D3506-1RevA

Manufactured No



Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

3

46538

3

Main Warehouse

ST

86

51789

86

December 2, 2009 8:01:19 AM

Shop Packet Print

Page 2

2 BE 09/12/08

2 09/12/07

4 BE 09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item Name: Skidtube Installation

Start Date: 02/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3506-3RevA Doubler		Manufactured	No			190	Each	106.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG

98

51790

98

Main Warehouse

LG

8

50563

8

MS20601-AD4W3

Purchased

No



Rivet

190

Each

234.0000

12.0000



Handwritten: 2 BE 02/12/08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

234

107823

3

111359

231

Handwritten: 12 BE 02/12/08

December 2, 2009 8:01:19 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 8:01:19 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation


Comments:

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			240	Each	2,748.000	38.0000			
<div>  </div>												
Insert												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2748	
105855	16	
108606	52	
111529	1356	
111779	313	
112772	11	
113238	1000	

x 38 H 09/12/10

ALS4-1032-225

Purchased

No



Insert

260 Each 7,318.000 1.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7318	
107441	16	
110768	7302	

x 1 H 09/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 8:01:19 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation


Start Date: 02/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			260	Each	1,327.000	31.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	1113359	x31 11/09/12/10
ST	1327	
112314	13	
112720	12	
112724	3	
112829	44	
112991	39	
113121	216	
113226	1000	

AN3C5A



Bolt

Purchased

No

260

Each

1,011.000 2.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1011	
111424	8	
111707	69	
112314	1	
112641	333	x2 11/09/12/10
113121	300	
113149	300	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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December 2, 2009 8:01:19 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526C1032R10 Purchased No



Screw

260 Each 530.0000 2.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

530

108062

127

108167

35

110049

368

42 09/12/10

AN960C10L

Purchased

No



washer

260 Each 1,820.000 33.0000

33.0000

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

1720

112116

512

112612

342

112933

866

433 09/12/10

December 2, 2009 8:01:19 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

December 2, 2009 8:01:19 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2965-3RevB

Manufactured

No

260

Each

13.0000

1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

50560

5

52282

8

260

Each

3.0000

1.0000

D2965RevB

Manufactured

No



Cap, 105 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP4

2

50924

2

Main Warehouse

ST

1

43288

1

X1 M 09/12/10

X1 M 09/12/10

December 2, 2009 8:01:19 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 8:01:19 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3492-041RevC

Manufactured

No

260

Each

140.0000

4.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

140

51584

140

260

Each

84.0000

4.0000

D3492-043RevC

Manufactured

No



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

84

52309

84

260

Each

48.0000

2.0000

D3492-047RevC

Manufactured

No



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

2776

1

28961

31

39722

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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December 2, 2009 8:01:19 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Start Date: 02/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3508-1RevC

Manufactured

No

260

Each

9.0000

1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

9

51261

9

260

Each

9.0000

1.0000

D3508-3RevC

Manufactured

No



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP21

9

51386

9

260

Each

8.0000

1.0000

D3508-5RevC

Manufactured

No



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP2

8

51388

8

xl 04/12/10

xl 04/12/10

xl 04/12/10

December 2, 2009 8:01:19 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 8:01:19 AM

Work Order ID: 54169



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 02/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3508-7RevC Wearplate		Manufactured	No			260	Each	9.0000	1.0000 			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP21

8

51389

8

Main Warehouse

ST

1

44518

1

xl 09/12/10

D3558-1RevB

Manufactured No



Gasket

260

Each

19.0000

1.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

19

50925

19

xl 09/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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December 2, 2009 8:01:20 AM

Work Order ID: 54169



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 02/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3558-3RevB

Manufactured

No

260

Each

14.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

45661

2

51391

12

xl del 04/12/10

D3558-5RevB

Manufactured

No

260

Each

10.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

50926

10

xl del 04/12/10

D3558-7RevB

Manufactured

No

260

Each

17.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

36388

2

43245

5

50927

10

xl del 04/12/10

December 2, 2009 8:01:20 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

December 2, 2009 8:01:20 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation


Start Date: 02/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-007		Purchased	No			260	Each	442.0000	2.0000			
												
O-RING												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

442

103697

442

260

Each

338.0000

4.0000

x2 ml oal 12/1/0

NAS1611-010

Purchased

No



O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

338

110715

44

110915

294

260

Each

138.0000

4.0000

x4 ml oal 12/1/0

NAS1611-013

Purchased

No



O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

138

106513

11

111424

20

111758

107

x4 ml oal 12/1/0

December 2, 2009 8:01:20 AM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

December 2, 2009 8:01:20 AM

Work Order ID: 54169



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation


Start Date: 02/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			280	Each	1,327.000	8.0000			



M113359 9/12/11 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1327	
112314	13	
112720	12	
112724	3	
112829	44	
112991	39	
113121	216	
113226	1000	

AN960C10L

Purchased

No

280

Each

1,820.000 8.0000



washer



9/12/11 SP (10)

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	1720	
112116	512	
112612	342	
112933	866	

8x

December 2, 2009 8:01:20 AM

Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 14

December 2, 2009 8:01:20 AM

Work Order ID: 54169

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3512-1RevC

Manufactured

No

280

Each

7.0000

2.0000



Wearplate

9/12/11 SP

bx

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST500

7

51390

7

2x

December 2, 2009 8:01:20 AM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

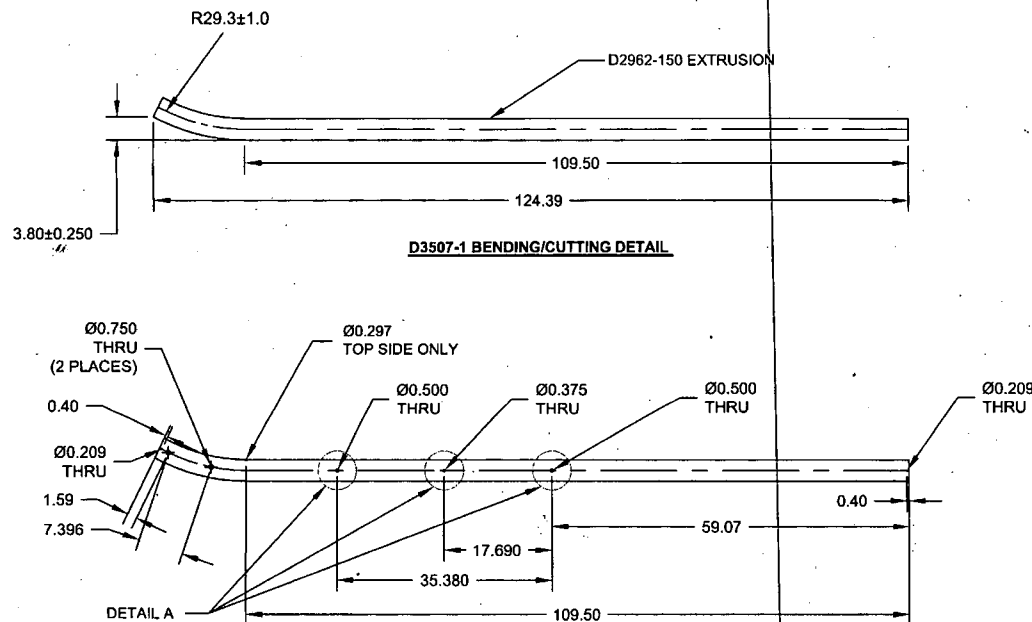
NOTE: Date & initial all entries

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
11	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN860C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN860C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JIC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE:	07.09.19		
DRAWING NO.		REV. C SHEET 1 OF 2	
TITLE		SCALE	
EC 135 SKIDTUBE		NT	
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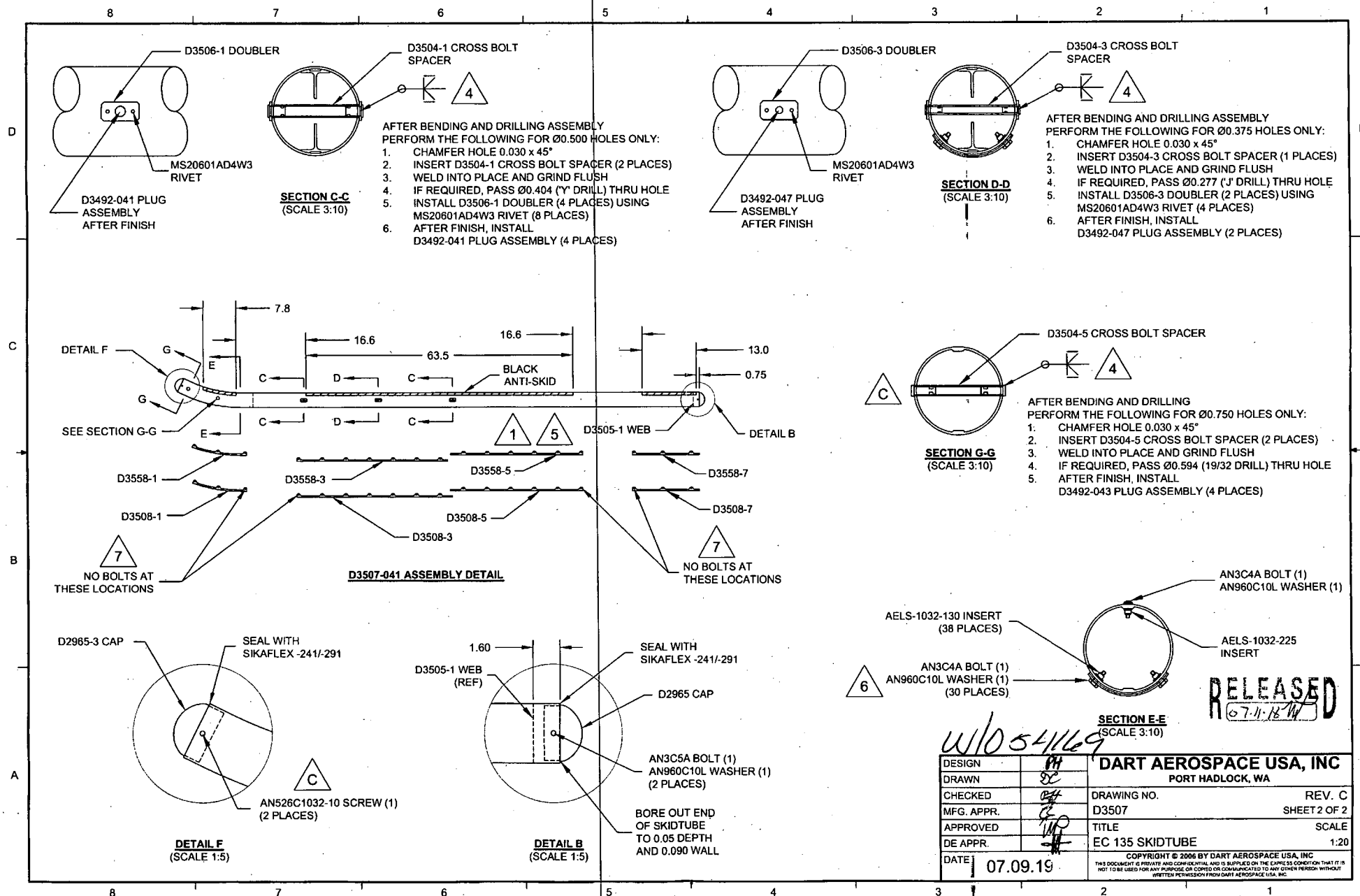


D3507-1 BENDING/CUTTING DETAIL

D3507-1 DRILLING DETAIL

DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 54169
PH 09-12-2



NO. 204

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 505370
Part number: D135 751 011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier J. D. Dml

Date of Test Coupon 09-07-16

Welder Barclay Elliott

Date of Test Coupon 09/07/16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld